

Work Order ID 75060

75060

Page 1

October-17-11 10:41:36 AM

Item ID: K642-511 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: saddle kit 642-511
 Start Date: 17/10/2011 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/10/17 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9467	Rev A								
IIN D206-642	Rev N								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-511	CHG004							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

MLJ 12-3-26
 (B)

12/3/23
30
 [SP]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75060***75060***

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October-17-11 10:41:36 AM

Item ID: K642-511 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: saddle kit 642-511
Start Date: 17/10/2011 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 28/10/2011 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K642-511 Location:								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF

12-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 75060

75060

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A07.06.05 new issueEC
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A *AN3C35A*		Purchased	No			110	Each	73.0000	3	9			

BOLT

Location	Loc Qty	Loc Code
FG	4	
18914	4	
ST353	69	
118628	19	
119125	50	

AN3C36A

AN3C36A

BOLT

Purchased No 110 Each 56.0000

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	
ST353	42	
119083	12	
119125	30	

AN3C41A

AN3C41A

BOLT

Purchased No 110 Each 84.0000

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	80	
119035	80	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75060

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Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

110

Each

242.0000

AN4C6A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

238

116704

15

118451

123

118983

100

121009

AN5C11A

Purchased

No

110

Each

152.0000

AN5C11A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

148

118706

48

118983

50

119127

50

AN5C12A

Purchased

No

110

Each

52.0000

AN5C12A

BOLT

**

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

50

118451

10

118983

40

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75060

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Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C13A
AN5C13A
BOLT

Purchased No

110 Each

103.0000

4

12

**

Location

Loc Qty

Loc Code

ST338

103

117872

28

118983

75

Purchased No

110 Each

65.0000

1

3

**

Location

Loc Qty

Loc Code

ST338

15

118191

15

ST339

50

118267

50

Purchased No

110 Each

111.0000

2

6

**

Location

Loc Qty

Loc Code

FG

4

18918

4

ST339

50

119035

50

ST340

57

116380

7

117407

25

117969

25

AN5C32A
AN5C32A

Purchased No

110 Each

111.0000

2

6

**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75060

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Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C34A
AN5C34A

Purchased No

110 Each 51.0000

**

Location

Loc Qty

Loc Code

FG

2

18918

2

ST339

20

119083

20

ST340

29

117950

18

118985

11

AN5C35A
AN5C35A

Purchased No

110 Each 47.0000

**

Location

Loc Qty

Loc Code

ST340

22

108407

22

ST341

25

118451

25

AN960C10L NAS1149C0332 R

Purchased No

110 Each 0.0000

**

***AN960C10I ***

washer

AN960C416L

Purchased No

110 Each 0.0000

**

***AN960C416I ***

WASHER

AN960C516L

NAS1149C0532 R

Purchased No

110 Each 0.0000

**

***AN960C516I ***

WASHER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75060

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Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

D206-648-013

Manufactured No

110 Each

4.0000

D206-648-013

GHW-Modification

CHW2

**

B78875

AP

Location

Loc Qty

Loc Code

FG120

4

74000

4

D2652

Manufactured No

110 Each

387.0000

D2652

Bushing

**

B77136

AP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

343

73833

343

D2712

Manufactured No

110 Each

1,091.000

D2712

Set Screw

**

B76065

AP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1041

71160

1

72231

90

73837

950

D2932-1

Manufactured No

110 Each

10.0000

D2932-1

Saddle LH Out, 206

**

B75096

12/3/23

34

Location

Loc Qty

Loc Code

ST428

10

72886

4

73466

6

Z

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75060

75060

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

D2933-1
D2933-1
Saddle LH In, 206

Manufactured No

110 Each

3.0000

1 3

24

12

**

B74603

76891

SP

Location

Loc Qty

Loc Code

ST428

3

72884

3

Manufactured No

110 Each

39.0000

2

6

**

B74883

SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

33

74501

33

Manufactured No

110 Each

34.0000

2

6

**

B74882

SP

Location

Loc Qty

Loc Code

ST027

34

74503

34

Manufactured No

110 Each

4.0000

1 3

**

B74605

12/3/23

3x

SP

Location

Loc Qty

Loc Code

ST428A

4

73468

4

D2938-1
D2938-1
Saddle LH Out, 206

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 75060

75060

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

D2939-1
D2939-1
Saddle LH In, 206

Manufactured No

110 Each 4.0000

1 3 (2*) (1*)
** 375099 74607

Location

Loc Qty

Loc Code

ST428A

4

73448

4

Manufactured No

110 Each 81.0000

2 6
** 57 88

D3396-3
D3396-3
Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

71

73349

71

Manufactured No

110 Each 13.0000

1 3
** 674519 12/3/23

D3407-043
D3407-043
Tow Ring

Location

Loc Qty

Loc Code

ST463

11

73341

11

ST464

2

68339

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 75060

75060

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

D3456-1

Manufactured No

110 Each

118.0000

- 1 3

D3456-1

Washer

**

B80252 SP

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

111

66848

3

71165

8

73493

100

D3457-1

Manufactured No

110 Each

28.0000

- 2 6

D3457-1

Washer

**

B70801 SP

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

18

67779

1

71849

17

D3672-1

Manufactured No

110 Each

360.0000

- 24 72

D3672-1

Phenolic Washer

**

B66821 12/3/26 SP

Location

Loc Qty

Loc Code

ST074

360

72229

360

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 75060

75060

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

D3672-3 Manufactured No

110 Each

867.0000

24 72

**

380370

SP

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

867

64176

180

72230

187

73487

500

D3672-7 Manufactured No

110 Each

284.0000

24 72

**

376279

SP

D3672-7

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

284

73488

284

MS21043-3 Purchased No

110 Each

921.0000

20 60

**

12/3/26

30 SP

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

849

118077

1

118614

492

118686

356

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75060

75060

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

110

Each

835.0000

13

39

MS21043-4

Nut

**

1120308 sl

30

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

795

117793

295

118686

500

MS21043-5

Purchased

No

110

Each

424.0000

4

12

MS21043-5

Nut

**

12/3/26 sl

30

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

304

112314

204

116548

100

ST314

100

118159

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
								X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7			1	1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	* WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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